

Date: Thursday, 3/9/2006 8:30:09 AM  
 User: Linda Lacelle

## Process Sheet

|                       |                                       |                  |                        |
|-----------------------|---------------------------------------|------------------|------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : BLOWER MOTOR SUPPORT |
| Job Number            | : 26171                               |                  |                        |
| Estimate Number       | : 12311                               |                  |                        |
| P.O. Number           | : N/A                                 | Part Number      | : D3471041             |
| This Issue            | : 3/9/2006 S.O. No. : N/A             | Drawing Number   | : D3471 REV.A          |
| Prsht Rev.            | : NC                                  | Project Number   | : N/A                  |
| First Issue           | : N/A Type : SMALL /MED FAB           | Drawing Revision | : A                    |
| Previous Run          | : N/A                                 | Material         | : N/A                  |
| Written By            | : SEE COMMENT BELOW                   | Due Date         | : 3/30/2006            |
| Checked & Approved By | : SEE ABOVE USER & DATE               | Qty:             | 1 Um: Each             |
| Comment               | : est rev A 06.03.02 New issue EC     |                  |                        |

## Additional Product

Job Number:



| Seq. #:   | Machine Or Operation: | Description :                 |
|---|-----------------------|-------------------------------|
| 1.0   | D3471043              | SUPPORT AND CLAMP ASSEMBLY    |
|   |                       |                               |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)<br>Pick:<br>qty part number description batch<br>2 D3471-043 CLAMP ASS'Y <del>① H100393</del> B 26268 |                       |                               |
| 2.0   | MS20470AD45           | Rivet, Universal Head         |
|   |                       |                               |
| Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)<br>Pick:<br>qty part number description batch<br>8 MS20470AD4-5 Rivet M18461                          |                       |                               |
| 3.0   | D34711                | BASE                          |
|   |                       |                               |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)<br>BASE D3471-1 B 26125   |                       |                               |
| 4.0   | SMALL FAB 1           | SMALL & MEDIUM FAB RESOURCE 1 |
|   |                       |                               |
| Comment: SMALL & MEDIUM FAB RESOURCE 1<br>Assemble as per dwg D3471   |                       |                               |
| 5.0   | QC5                   | INSPECT WORK TO CURRENT STEP  |
|   |                       |                               |
| Comment: INSPECT WORK TO CURRENT STEP   |                       |                               |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 8:30:10 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26171

Part Number: D3471041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |             |                       |
|-----|-------------|-----------------------|
| 6.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 04/03/29 1

|     |    |                  |
|-----|----|------------------|
| 7.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

06/03/30

Job Completion



06.03.30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

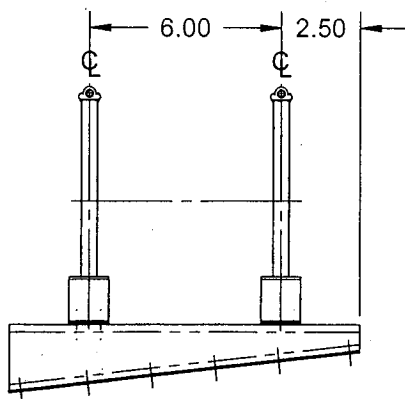
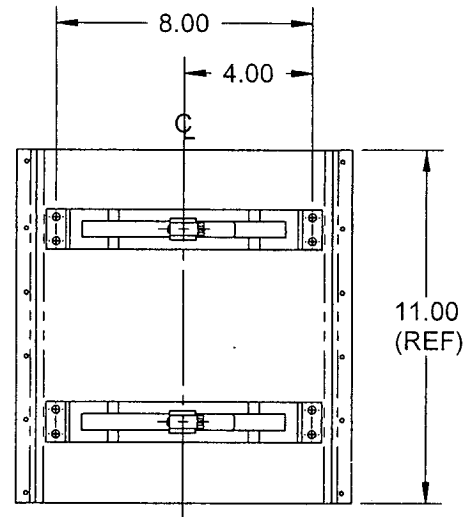
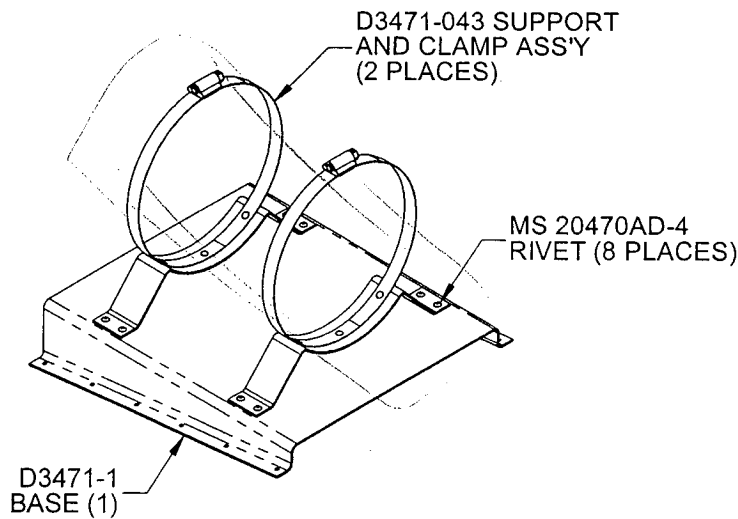
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

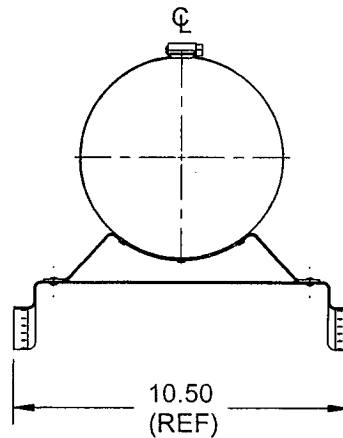
NOTE: Date & initial all entries

PRELIMINARY ISSUE

|                       |                         |   |                        |
|-----------------------|-------------------------|---|------------------------|
| DESIGN<br>[Signature] | DRAWN BY<br>[Signature] | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED               | APPROVED                | DRAWING NO.<br>D3471                              | REV. A<br>SHEET 1 OF 5 |
| DATE<br>05.12.21      |                         | TITLE<br>BLOWER MOTOR SUPPORT                     | SCALE<br>1:6           |
| A                     | 05.12.21                | NEW ISSUE   |                        |



Parts List



### D3471-041 BLOWER MOTOR SUPPORT

#### NOTES:

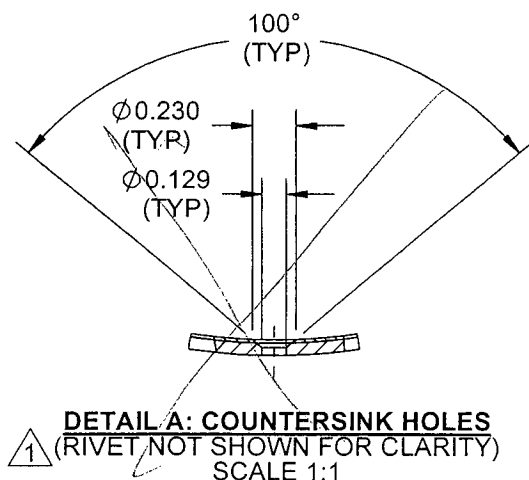
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# PRELIMINARY ISSUE

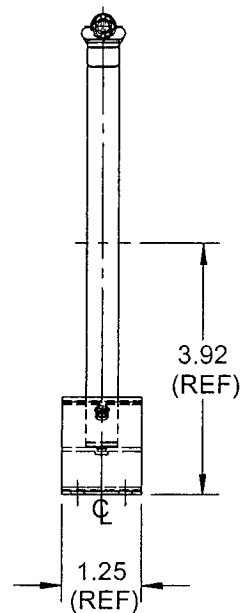
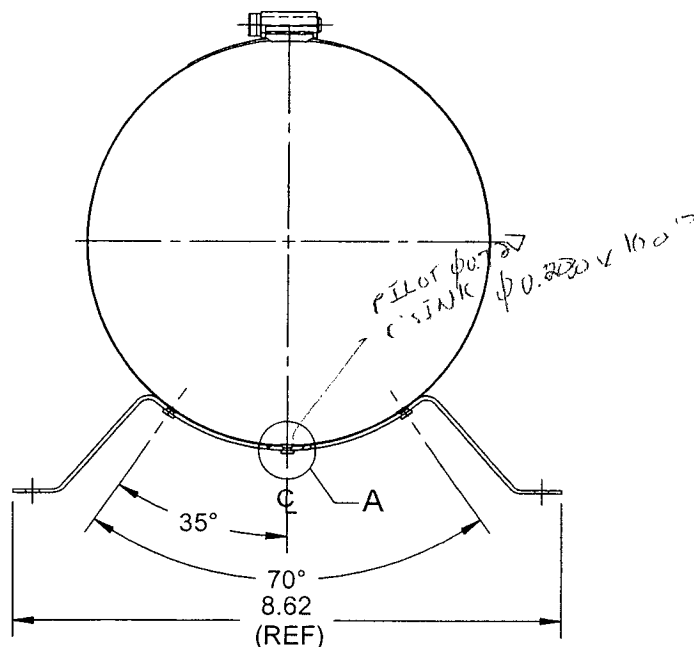
|                           |                             |   |                        |
|---------------------------|-----------------------------|---|------------------------|
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| DATE<br>05.12.21          |                             | TITLE<br>BLOWER MOTOR SUPPORT                     | SCALE<br>1:3           |



MS35842-16 CLAMP  
(2 PLACES)

MS20427M4 RIVET  
(3 PLACES)

D3471-3



## D3471-043 SUPPORT AND CLAMP ASS'Y

### NOTES:

- 1) LOCATE MS35842-16 CLAMP AND TRANSFER DRILL #30 (0.129") HOLES FROM D3471-3 TO MS35842-16 CLAMP. COUNTERSINK AS SHOWN ON DETAIL A (3 PLACES).
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| DATE<br><b>05.12.21</b> |          | TITLE<br><b>BLOWER MOTOR SUPPORT</b>                     | SCALE<br><b>1:4</b>    |

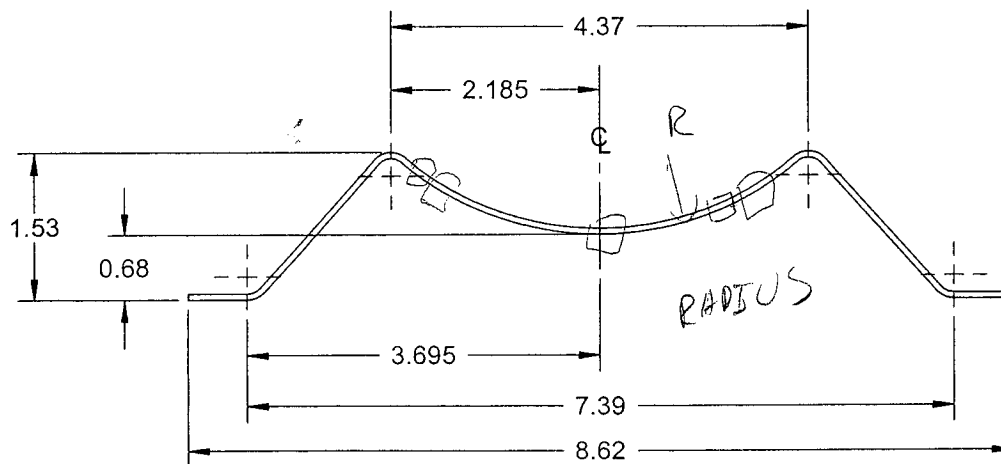
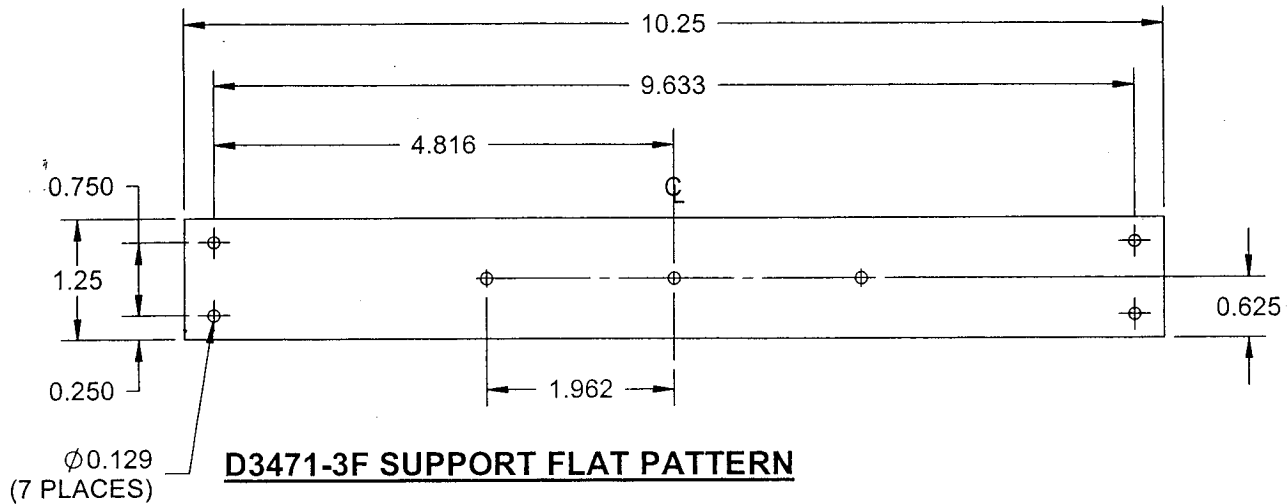


- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| DATE<br>05.12.21             |                                | TITLE<br>BLOWER MOTOR SUPPORT                     | SCALE<br>1:2           |



**NOTES:**



- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

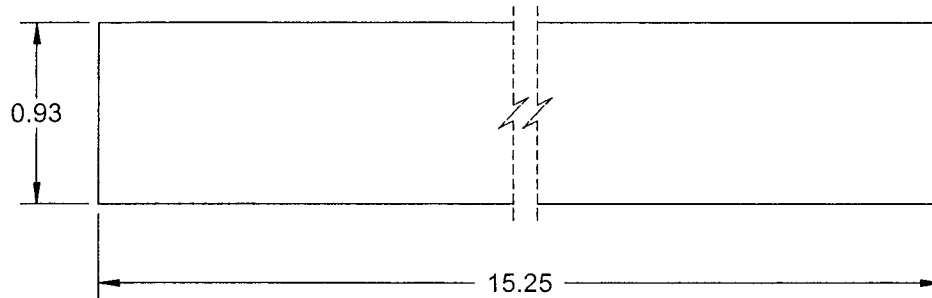
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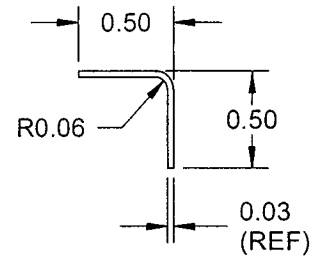


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| DATE<br>05.12.21   |  | TITLE<br>BLOWER MOTOR SUPPORT                     | SCALE<br>1:1           |



**D3471-5F STIFFENER FLAT PATTERN**



**D3471-5 STIFFENER  
BENDING DETAIL**

**D3471-5 STIFFENER**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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